

Ship. Nov. 30

Work Order ID 153201

153201

Page 1

Wednesday, November 09, 2016 3:34:17 PM

Item ID: D3936-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mapbox Assembly

Start Date: 11/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

6-11-09

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3936

A

100

0.00

100

Small Fab

Memo

0.14

Small Fab

1- Transfer drill holes and c'sink as per dwg (D3936-1/-3/-5)

2- Deburr

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

114

Chemical Conversion Coat per QSI005 4.1

0.00

114

HandFinish

Memo

0.10

Hand Finishing

DAS
30
9-89

NOV 17 2016

D/S
16
11/18

BEB

NOV 10 2010

Work Order ID 153201

Wednesday, November 09, 2016 3:34:17 PM

153201

Page 3

Item ID: D3936-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mapbox Assembly

Start Date: 11/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				1	0	16-11-21.	DAS 34 9-89
120									
Powdercoat	Memo	0.02							
Powder Coating	START TIME: 8:00								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 8:30								
130	QC3- Inspect Part Finish	0.00				1X		16/11/21	DAS 36 9-89
130									
QC	Memo	0.00							
Quality Control									
140		0.00				1X		16/11/21	DAS 36 9-89
140									
Small Fab	Memo	0.02							
Small Fab	INSTALL RUBBER CUSHION AND PLACARD AS PER DWG								

Work Order ID 153201

Wednesday, November 09, 2016 3:34:17 PM

153201

Page 4

Item ID: D3936-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Mapbox Assembly

Start Date: 11/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89
NOV 21 2016

160

Identify as per dwg & Stock Location: St Sold

0.00

160

Packaging

Memo

0.00

Packaging

DAS
6
9-89
NOV 21 2016

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.02

Quality Control

DAS
21
9-89

NOV 21 2016

Wednesday, November 09, 2016 3:34:26 PM

age 1

153201

D3936-041

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3936-1		Manufactured	No			100	Each	0.0000	1	1		NOV 17 2016	
D3936-1 Sides B 153202 ** DAS 30 9-89													
D3936-3		Manufactured	No			100	Each	0.0000	1	1		NOV 17 2016	
D3936-3 Bottom B 153204 ** DAS 30 9-89													
D3936-5		Manufactured	No			100	Each	0.0000	1	1		NOV 17 2016	
D3936-5 Divider B 153203 ** DAS 30 9-89													
D3938-3		Manufactured	No			140	Each	10.0000	1	1		NOV 17 2016	
D3938-3 Placard ** DAS 30 9-89													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		10							
				133307		10							
D3941-40		Purchased	No			140	Each	1.0000	1	1		NOV 17 2016	
D3941-40 Rubber Cushion 40" Long ** DAS 30 9-89													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		1							
				63061		1							

CUT (1x) 40.00" PER DWG

Picklist Print

Wednesday, November 09, 2016 3:34:26 PM

Page 2

Work Order ID: 153201

153201

Parent Item: D3936-041

D3936-041

Parent Item Name: Mapbox Assembly

Start Date: 11/14/2016

Required Date: 11/24/2016

Start Qty: 1.00

Required Qty: 1.00

D3941-12 Purchased No

140 Each 1.0000 1 1

D3941-12

Rubber Cushion 12" Long

**

DAS
36
9-89

16/11/21

Location

Loc Qty

Loc Code

ST060

1

63062

1

CUT (1X) 12.00" PER DWG

MS20426AD3-4

Purchased No

100 Each 4,275.000 56 56

MS20426AD3-4

RIVET

**

DAS
36
9-89

16/11/18

Location

Loc Qty

Loc Code

ST312

4275

m134294

4275

MS20426AD3-5

Purchased No

100 Each 3,802.000 8 8

MS20426AD3-5

Rivet

**

DAS
36
9-89

16/11/18

M135274 (56x)

Location

Loc Qty

Loc Code

GA

2386

4533

2386

ST312

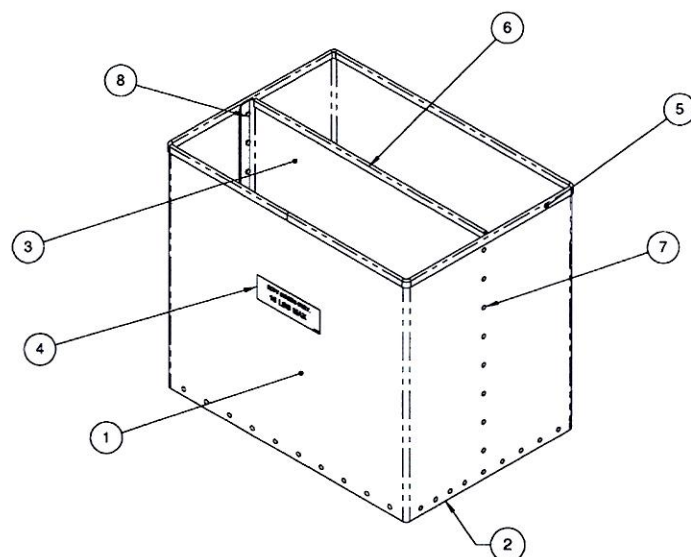
1416

4533

1416

M131697
(6x)

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET



D3936-041 MAPBOX ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 2.54 lbs

ASSEMBLY INSTRUCTIONS

1. BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
2. POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
3. POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
4. TRANSFER DRILL 10X $\phi 0.098$ (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
5. TRANSFER DRILL 38X $\phi 0.098$ HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
6. REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES $\phi 0.179 \times 100^\circ$. DEBURR ALL HOLES IN ALL PARTS.
7. REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
8. RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
9. RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
10. RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
11. POWDER COAT ASSEMBLY PER NOTE 2.
12. TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
13. REMOVE RUBBER CUSHION.
14. APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
15. SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
16. WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
17. APPLY D3938-3 PLACARD AS SHOWN.
18. ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153201
MP 16-11-09

RELEASED
2009-08-28
MP

A		NEW ISSUE		09.07.08	
REV.		DESCRIPTION	BY	DATE	
DESIGN	PF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3936 TITLE MAPBOX			
DRAWN	PF				
CHECKED	ALS				
MFG. APPR.	PF				
APPROVED	MP				
DE APPR.	MP				
DATE		09.07.08			

REV. A
SHEET 1 OF 7
SCALE
NTS

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

